

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001155**Date Inspected:** 27-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG Deck Trial**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Bay 1: The QA inspector conducted partial visual examination on the orthotropic box girder (OBG) deck mock up assembly. The QA inspector was informed that welds needed to be examined to further identify their conformance to AWS D1.5 2002. The QA inspector conducted visual examination on both sides of diaphragm stiffener #1 and 1 side (Y-) of diaphragm stiffener #2. The QA inspector noted that the welds appear to have rust and ultrasonic couplant across areas of the welds and the visual examination is impeded by this condition. Of the welds examined by the QA inspector, 10 sections of the welds appeared to have undercut visible and measurable at 1.0mm or greater. These areas were marked and a rough drawing of the general locations was made. This information was given to the QA inspector Alfredo Acuna for consolidation and further inquiry. The QA inspector did not observe any welding, cutting, or fitting in progress during this shift today.

**Summary of Conversations:**

The QA inspector Scott Croff was directed to conduct visual examination of the OBG deck trial assembly. The QA inspector relayed the notes of the observations to the QA inspectors Bruce Berger and Alfred Acuna. There were no other notable conversations during this shift.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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## WELDING INSPECTION REPORT

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for your project.

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<b>Inspected By:</b>	Croff,Scott	Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer
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